

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000123**Date Inspected:** 17-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, California**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Robert Cuellar is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/ Fluor for the continuing purpose of witnessing Procedure Qualification Record tests. The following items have been observed,

1) The Caltrans QA Inspector observed the following personnel present, Smith Emery Certified Welding Inspector Mr. Michael Johnson, ABF Welding Superintendent Mr. Tommy Gibson, ABF Welding Quality Control Manager Mr. James Bowers (Present for approximately 1 hour in the morning) and also welder Mr. Dan Gordon.

2) Today's observation is of the continuation of a procedure qualification record (PQR) test that is identified as ABF-PQR-001-2, third attempt. Prior to the start of this PQR test, ABF representatives and the Quality Control Inspector met and discussed the current status of this PQR test. At the conclusion of this conversation ABF elected to terminate this PQR test due to the welder complaining that the welding parameters being attempted do not provide a comfortable weld ability that he prefers to utilize. ABF elected to proceed with a new PQR test utilizing the same PQR identification number, ABF-PQR-001-2. Welder Mr. Dan Gordon was observed removing the four flux cored arc welding (FCAW) filler passes that have been applied in an effort to utilize this PQR test plate assembly for the subsequent welding of a new PQR test plate assembly as listed below.

3) ABF-PQR-001-2 (Forth Attempt)-The Caltrans QA Inspector visually observed and recorded that welder Mr. Dan Gordon applied twelve flux cored arc welding (FCAW) weld passes to the PQR test plate assembly. FCAW filler weld pass number eleven was removed by grinding as elected by ABF due to the welding parameters being approximately 14% out of the qualifying range for the travel speed being attempted. The visual appearance of the last FCAW pass applied contained visual discrepancies relative to surface linear porosity. ABF has voiced that they would attempt to remove such surface linear porosity by grinding prior to applying subsequent weld passes. The FCAW of this PQR test plate assembly was not completed on this date.

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## WELDING INSPECTION REPORT

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For specific welding parameter values recorded during this procedure qualification record test see the Caltrans TL-6032 generated for this date. Digital pictures that support today's observations are included within the TL-6032.

### Summary of Conversations:

1) Mr. Tommy Gibson voiced that PQR testing would resume on Wednesday 04-18-2007. 2) The Caltrans QA Inspector questioned Mr. Tommy Gibson and also Mr. Mike Johnson as to whether or not the attempted PQR tests performed to date are to be utilized for Seismic Performance Critical Members (SPCMs). Mr. Tommy Gibson and Mr. Mike Johnson responded that they did know. The Caltrans QA Inspector suggested that such information should be sought out utilizing the ABF Quality Control Manager, Mr. James Bowers.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Cuellar,Robert	Quality Assurance Inspector
<b>Reviewed By:</b>	Smith,Ryan	QA Reviewer

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